



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

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D2667-1

Job Sheet 208428



Part No: D2667-1

Job Qty: 6 pcs

Part Name: Saddle, LH, Aft, Out



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 3/19/20

Job Tracking No:

Due Date: 4/13/20

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV D IPP: C 00.11.01 Removed P/O for Powder Coat - in house process EC IPP Rev:D As per Rev D
07-03-19 JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	HAAS 4 Axis	6 pcs	4/13/20		1.00	10.44	HAAS - 1		
							HAAS - 2		
							HAAS - 3		SBL 20/04/07
							HAAS - 4		
110	Conventional Mill - 1 - B4B	6 pcs	4/13/20		0.00	10.44	Conventional Mill - 1 - B4B		SBL 20/04/08
							Conventional Mill - 2 - B4B		
120	QC 2	6 pcs	4/13/20		0.00	0.00	QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		



Dart Aerospace Ltd.
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Container No: S269172



Part: D2667-1

Job No: 208428

Serial No/Batch: S269172

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Date: 04/07/20

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130	QC 8	6 pcs	4/13/20	0.00	0.00	QC 2 - 57	SBL 20/04/08
						QC 2 - 62	
						QC 2 - 63	
						QC 2 - 8	
						QC 2 - 66	
						QC 2 - 64	
						QC 2 - 65	
						QC 2 - 5	
						QC 2 - 71	
						QC 2 - 73	
						QC 2 - 69	
						QC 2 - 76	
						QC 2 - 86	
						QC 8 - 12	
						QC 8 - 14	20/04/08
						QC 8 - 17	
						QC 8 - 20	
140	Handfinish - 1-1 Chemical-B4B	6 pcs	4/13/20	0.00	0.41	QC 8 - 25	
						QC 8 - 3	
						QC 8 - 32	
						QC 8 - 33	
						QC 8 - 35	
						QC 8 - 39	
						QC 8 - 4	
						QC 8 - 44	
						QC 8 - 45	
						QC 8 - 49	
						QC 8 - 58	
						QC 8 - 8	
						QC 8 - 9	
						QC 8 - 68	
						QC 8 - 67	
						QC 8 - 1 (A)	
						QC 8 - 47	
						QC 8 - 40	
						QC 8 - 52	
						QC 8 - 23	
						QC 8 - 57	
						QC 8 - 76	
						QC 8 - 61	
						Handfinish - 1 - 1 - B4B	
						Handfinish - 1 - 2 - B4B	BER 20-04-13
						Handfinish - 1 - 3 - B4B	
						Handfinish - 1 - 4 - B4B	
						Handfinish - 1 - 5 - B4B	
						Handfinish - 1 - 6 - B4B	
						Handfinish - 1 - 7 - B4B	
						Handfinish - 1 - 8 - B4B	
						Handfinish - 1 - 9 - B4B	
						Handfinish - 1 - 10 - B4B	
						Handfinish - 1 - 11 - B4B	
						Handfinish - 1 - 12 - B4B	
						Handfinish - 1 - 13 - B4B	
						Handfinish - 1 - 14 - B4B	
						Handfinish - 1 - 15 -	

				B4B	
				Handfinish - 1 - 16 - B4B	
				Handfinish - 1 - 17 - B4B	
				Handfinish - 1 - 18 - B4B	
				Handfinish - 1 - 19 - B4B	
				Handfinish - 1 - 20 - B4B	
				Handfinish - 1 - 21 - B4B	
				Handfinish - 1 - 22 - B4B	
150	Powdercoat - 1 White Gl(A)- B4B	6 pcs	4/13/20	0.00 0.33	Powdercoat - 1 - B4B
					Powdercoat - 2 - B4B
					Powdercoat - 3 - B4B
					Powdercoat - 4 - B4B
160	QC 3	6 pcs	4/13/20	0.00 0.00	QC 3 - 10
					QC 3 - 13
					QC 3 - 15
					QC 3 - 17
					QC 3 - 18
					QC 3 - 2
					QC 3 - 28
					QC 3 - 3
					QC 3 - 30
					QC 3 - 34
					QC 3 - 36
					QC 3 - 41
					QC 3 - 51
					QC 3 - 58
					QC 3 - 59
					QC 3 - 68
					QC 3 - 9
					QC 3 - 40
					QC 3 - 19
					QC 3 - 43
					QC 3 - 24
					QC 3 - 61
					QC 3 - 81
					QC 3 - 82
170	Packaging 3-1 - Stock - B4B	6 pcs	4/13/20	0.00 0.00	Packaging 3 - 1 - B4B
					Packaging 3 - 2 - B4B
					Packaging 3 - 3 - B4B
					Packaging 3 - 4 - B4B
					Packaging 3 - 5 - B4B
					Packaging 3 - 6 - B4B
					Packaging 3 - 7 - B4B
					Packaging 3 - 8 - B4B
					Packaging 3 - 9 - B4B
					Packaging 3 - 10 - B4B
					Packaging 3 - 11 - B4B
					Packaging 3 - 12 - B4B
					Packaging 3 - 13 - B4B
					Packaging 3 - 14 - B4B
					Packaging 3 - 15 - B4B
					Packaging 3 - 16 - B4B
					Packaging 3 - 17 - B4B

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				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 37 - B4B	
180 QC 21 - SA	6 pcs	4/13/20	0.00 0.00	QC 21 - SA - 21	DAS
				QC 21 - SA - 70	21
				QC 21 - SA - 53	9-89

APR 15 2020

Part Op 100 - Program batch number. 1-Inspect part number and batch number are programmed correctly. 3-Fixturing Inspection
 Descriptions: last completed on 3/16/20 by SBL 4-Machine Step No 1 of Folio and visually inspect as per attached Dimension
 Sheet 5-Machine Step No 2 of F
 110 - Machine Keyway and inspect per attached dimension sheet
 120 - QC2- Inspect parts off machine FAI/FAIB
 130 - QC8- Inspect parts - second check
 140 - Chemical Conversion Coat per QSI005 4.1
 150 - White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum START TIME: _____ OVEN TEMPERATURE: _____
 FINISH TIME: _____
 160 - QC3- Inspect Part Finish
 170 - Identify as per dwg & Stock Location: _____
 180 - QC21- Final Inspection - Work Order Release

Job BOM				
Part / Item	Component Name	Quantity	Operation	Container
D6101-003	Saddle Billet, 7075	6 pcs (1 ea)	100-HAAS 4 Axis	<u>5261891</u>

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
100-HAAS 4 Axis	D6101-003	6	36	0

Part Specifications
Specifications could not be found.

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DART AEROSPACE LTD		Work Order: 708428
Description: 206 Saddle, Outboard, Left side		Part Number: D2667-1
Inspection Dwg: D2667 Rev: D DSK: Rev:		Page 1 of 1

FIRST ARTICLE INSPECTION DIMENSION SHEET

Dim	Min	Max	Go/No Go Gauge	Record Actual Dimensions				
				1	2	3	4	5
A	0.100	0.140		.121	.121	.120	.120	.120
B	0.100	0.140		.127	.128	.128	.128	.128
C	1.125	1.145		1.135	1.135	1.135	1.135	1.135
D	0.615	0.685		.660	.655	.655	.655	.655
E	0.240	0.260		.251	.252	.250	.251	.251
F	1.313	1.343		1.321	1.320	1.320	1.320	1.320
G	0.210	0.230		.221	.221	.220	.220	.220
H	0.100	0.180		.133	.131	.130	.133	.133
I	2.470	2.510		2.490	2.493	2.492	2.492	2.493
J	1.565	1.585		1.575	1.575	1.575	1.575	1.575
K	0.235	0.240		.238	.237	.237	.237	.237
L	0.100	0.120		.113	.113	.113	.113	.113
M	0.990	1.010		1.004	1.003	1.003	1.002	1.003
N	0.510	0.515		.512	.512	.512	.512	.512
O	5.990	6.010		6.003	6.003	6.003	6.003	6.002
P	1.245	1.255		1.250	1.250	1.250	1.250	1.250
Q	2.495	2.505		2.500	2.500	2.500	2.500	2.500
R	0.312	0.318		.312	.312	.312	.312	.312
S	0.315	0.322		.316	.316	.316	.316	.316
T	1.995	2.005		2.000	2.000	2.000	2.000	2.000
U	1.357	1.367		1.362	1.362	1.362	1.362	1.362
V	0.787	0.807		.795	.795	.794	.795	.795
W	1.040	1.060		1.050	1.049	1.049	1.049	1.048
X	1.674	1.679		1.679	1.679	1.679	1.679	1.679
Y	0.256	0.262		.258	.258	.258	.258	.258
Z	0.912	0.932		.921	.922	.923	.923	.923
AA	0.490	0.510		.503	.500	.501	.499	.501
AB	0.178	0.198		.188	.188	.188	.188	.188
AC								
AD								
AE								
Accept/Reject								

Measured by: SBL	Date: 20/04/07
Audited by: MK	Date: 20/04/08
Prototype Approval:	Date:

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	99.04.19	Incorporated DSI 9095, DSI 9102 & DSI 9122 Rev. A	RF	
C	99.11.11	Added Dim. R-T	RF	
D	02.12.12	Reformat; Added Dim. U-W & DT8683, DT8686	KJ/RF	
E	06.07.05	Revised per drawing revision C	KJ/JLM	
F	07.03.21	Revised per drawing revision D	KJ/JLM	
G	12.03.08	Revised dimensions R and Y	KJ	M

DART AEROSPACE LTD		Work Order: <i>208428</i>
Description: 206 Saddle, Outboard, Left side		Part Number: D2667-1
Inspection Dwg: D2667 Rev: D DSK: Rev:		Page 1 of 1

FIRST ARTICLE INSPECTION DIMENSION SHEET

Dim	Min	Max	Go/No Go Gauge	Record Actual Dimensions				
				6	7	8	9	5
A	0.100	0.140		120				
B	0.100	0.140		128				
C	1.125	1.145		1135				
D	0.615	0.685		655				
E	0.240	0.260		251				
F	1.313	1.343		1320				
G	0.210	0.230		220				
H	0.100	0.180		133				
I	2.470	2.510		2495				
J	1.565	1.585		1575				
K	0.235	0.240		238				
L	0.100	0.120		113				
M	0.990	1.010		1003				
N	0.510	0.515		512				
O	5.990	6.010		6002				
P	1.245	1.255		1250				
Q	2.495	2.505		2500				
R	0.312	0.318		312				
S	0.315	0.322		316				
T	1.995	2.005		2000				
U	1.357	1.367		1362				
V	0.787	0.807		795				
W	1.040	1.060		1049				
X	1.674	1.679		1679				
Y	0.256	0.262		258				
Z	0.912	0.932		921				
AA	0.490	0.510		499				
AB	0.178	0.198		188				
AC								
AD								
AE								
Accept/Reject								

Measured by: <i>SBC</i>	Date: <i>20/04/08</i>
Audited by: <i>mx</i>	Date: <i>20/04/08</i>
Prototype Approval:	Date:

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	99.04.19	Incorporated DSI 9095, DSI 9102 & DSI 9122 Rev. A	RF	
C	99.11.11	Added Dim. R-T	RF	
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E	06.07.05	Revised per drawing revision C	KJ/JLM	
F	07.03.21	Revised per drawing revision D	KJ/JLM	
G	12.03.08	Revised dimensions R and Y	KJ	<i>M</i>

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QS1042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details: _____					